

Work Order ID 56424

February 23, 2010 12:51:53 PM



Page 1

Item ID: D6201

Accept



Setup Start



Revision ID:

Item Name: "T" Extrusion

Stop



Start Date: 2/23/10 Start Qty: 12.00



Cust Item ID:

Required Date: 3/01/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D6201

Rev A

0.00

100



PURCHASING

Purchasing

Memo

0.00

Issue P/O: 11410 a)Description: T-beam extrusion b) 4.00" x 4.00" x 0.375" c) Minimum Ultimate Tensile Strength = 38ksi d) Minimum Yield Tensile strength = 35ksi e) Material: 6061-T6/T6511 (QQ-A-200/8)

f)Material certification required

110



Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

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Page 2

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Cust Item ID:

Required Date: 3/01/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC6- Inspect dimensions to drawing

Set Up/
Run Hours

0.00

S. colors 03

Draw
Number

0.00

Draw
Rev.

0.00

Plan
Code

0.00

Accept
Qty

+1

Reject
Qty

0.00

Reject
Number

*20 feet long

Insp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

140



QC

Quality Control

Memo

0.00

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Picklist Print

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1

Work Order ID: 56424



Parent Item: D6201



Parent Item Name: "T" Extrusion

Start Date: 2/23/10

Required Date: 3/01/10

Comments: IPP A: 01.05.15 New Issue EC

Start Qty: 12.00

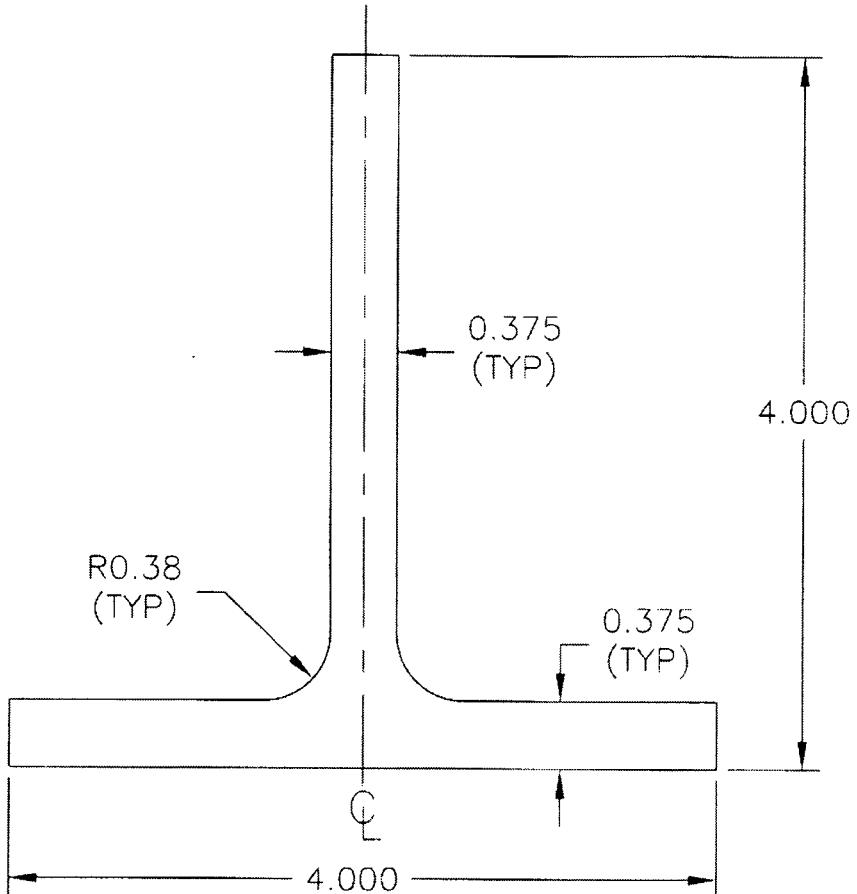
Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6201P T Extrusion 4X4X3/8		Purchased		No		110	f	0.0000	12.0000 		2/23/10 (20)	

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>PS</i>	DRAWING NO. D6201	REV. A SHEET 1 OF 1
DATE 01.04.10	TITLE T-BEAM EXTRUSION		SCALE 1:1
A	01.04.10	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



D6201-XXX T-BEAM EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6201-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM "T"-EXTRUSION ROUND FILLET
4.000" x 4.000" x 0.375"
6061-T6/T6511 (QQ-A-200/8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Valleyfield (Québec)
J6S 5L1

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FAX : 450 377-5696

MONTRÉAL : 514 336-4248
FAX : 514 336-4248

ONTARIO : 1 800 667-4248
FAX : 1 866 456-4242

VENDU À / SOLD TO:

613-632-5200 **613-632-1053**

EXPEDIEZ A /SHIP TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

VOTRE N° DE COMMANDE / YOUR NO. : VEND. / SALESM. CODE CLIENT / CUST. CODE EXPÉDIE PAR / SHIP VIA TERMES / TERMS. MÉTHODE DE PAIEMENT / PAYMENT METHODS PAGE NO.

P011410	D	DAER		NET 30 JOURS	2R		001
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* Unités de mesure : CLB Centimètres • CPI Centipieds • UN Unité • PI Pied
 Units of measure: CLB Centimeters • CPI Centipedes • UN Unit • PI Foot
 Hundred pounds • Hundred feet • Inch • Square foot

**POIDS TOTAL
TOTAL WEIGHT**

CONDITIONS:

**ALL SOLD AND DELIVERED MATERIALS REMAIN THE PROPERTY OF "AEGEN GROUP INC." UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHED.
ALL SOLD MATERIALS ARE AT THE BUYER'S EXPENSE. • ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER.
THE BUYER HEREBY AGREES TO RESPECT THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE, AND THE BUYER AGREES TO PAY AN
ADMINISTRATION CHARGES OF 2% PER MONTH OR 24% PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 90 DAYS. • ANY DELAY IN REQUESTING AN
EXPLANATION OF CHARGES WILL LEAD TO PAYMENT BY ACCELERATION AND PENALTIES TO THE SELLER. AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE
REPOSESSION OF THE GOODS SOLD. • ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. • ANY INCHARGE MADE THAT
HAS BEEN DETERMINED BY THE NECESSARY AUTHORITY CANNOT BE RETURNED. • ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND WILL SUBJECT
TO A 25% RESTOCKING CHARGE.**

MARCHANDISE REÇUE EN BONNE CONDITION / MERCHANDISE RECEIVED IN GOOD CONDITION

PREPARED / PREPARED: ✓ VERIFIED / VERIFIED

LIVRE / DELIVERED

A/Y N/M J/D

۲۴۹

PAR
BY

PAR
AV

x

TOTAL

**SOUS-TOTAL
SUB TOTAL**

T.P.S.
GST

T.V.Q.
Q.S.T.

731240

PQ H7S-1 N22214
 SOLD TO PURCHASE ORDER 09/09/09
 DATE PRINTED

V872002 TER 4.000X4.000X.375
 CUSTOMER PART NUMBER DESCRIPTION

R559563 734563-003 C9428 142
 RELEASE-ITEM LOT

6061-T6
 ALLOY/TEMPER

8
 7/10/09
 Kaiser Day

MECHANICAL PROPERTY RESULTS

REFERENCE	SAMPLE#	UTS (KSI)	YTS (KSI)	ELONG%	HARDNESS	CONDUCT.	BEND
C9428 142	0001 1	50.1	44.3	14.8	RE 97	N/A	N/A

CHEMICAL COMPOSITION (WT%), ALUMINUM REMAINDER

6061 LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Ea	Others	Tot
Maximum	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	NA	NA	NA	0.05	0.15	
Minimum	0.40		0.15		0.8	0.04			NA	NA	NA			

8
 7/10/09/03

Applicable Requirements:

ASTM-B308-02-STENCILED
 EXCEPT HARDNESS TESTED PER
 C=0,1.5 AQL SAMPLING PLAN
 ASTM-B221-08 (AMS-QQ-A-200/8)
 AMS-QQ-A-200/16 UNS#96061
 ASME-SB221 1998 SECT II

hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file, subject to examination.

Bill Brennan
 Technical Manager